

WHAT IS CLAIMED IS:

1. A binder comprising:

binding rings;

a holding member having a length that allows said binding
5 rings to be arranged with a spacing therebetween; and

an operating member on a surface of which said binding
rings are anchored at bases thereof with spacing therebetween,
and which is movably fixed to an inner side of said holding
member such that the binding rings are fixed to the holding
10 member;

the operating member including a pair of operating pieces
moving within the holding member in a longitudinal direction
of the holding member, and a pivot shaft portion arranged
along abutting edges of said pair of operating pieces;

15 one of the bases of each of the binding rings being fixed
to one of said operating pieces and the other of the bases
being fixed to the other operating piece;

the binder also including an opening/closing member that,
for opening the binding rings, moves the operating pieces
20 within the holding member in the longitudinal direction of the
holding member, while rotating the pair of operating pieces
around said pivot shaft portion in directions so as to open
the binding rings.

25 2. The binder according to claim 1, wherein substantially

cylindrical slide portions are provided along the abutting edge of one of said operating pieces at spaced intervals and cylindrical slide portions are disposed along the abutting edge of the other operating piece so as to be loosely fitted
5 between said substantially cylindrical slide portions, a pivot shaft being arranged to pass through the substantially cylindrical slide portions.

3. The binder according to claim 1, wherein the
10 opening/closing member is provided in a gap defined between the substantially cylindrical slide portions of the operating pieces.

4. The binder according to claim 1, wherein a gap is
15 defined between the substantially cylindrical slide portions of the operating pieces so that the opening/closing member is provided in the gap; and

an inner end of the cylindrical slide portion of one of the operating pieces faces said gap, and, in opposition to the
20 inner end, an inner end of the substantially cylindrical slide portion of the other operating piece faces said gap.

5. The binder according to claim 1, wherein a first pivot shaft piece is disposed at the abutting edge of one of the
25 operating pieces, a second pivot shaft piece is disposed at

the abutting edge of the other operating piece to be overlapped with the first pivot shaft piece, and a pivot shaft is passed between said first and second pivot shaft pieces.

5 6. The binder according to claim 1, wherein a gap is disposed at the abutting edges of the operating pieces so that the opening/closing member is provided in the gap, a gap-side inner end of one of the operating pieces faces the gap, and, in opposition to the gap-side inner end, a gap-side inner end
10 of the other operating piece faces the gap.

 7. The binder according to claim 1, wherein said opening/closing member includes an elastic member, and said elastic member is provided between a pair of operating pieces
15 constituting said operating member for moving the pair of operating pieces in the opposite directions, respectively, and for elastically urging the pair of operating pieces in the directions to hold the binding rings in the opened or closed state.

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 8. The binder according to claim 1, wherein the elastic member includes a coil spring and the coil spring is wound around the pivot shaft of the operating member, and arranged in contact with the substantially cylindrical slide portion of
25 one of the operating pieces of the operating member and with

the substantially cylindrical slide portion of the other operating piece such that one end of the coil spring presses one of the operating pieces of the operating member, and the other end pressing the other operating piece.

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9. The binder according to claim 1, wherein the elastic member includes a coil spring, and the coil spring is wound around the pivot shaft portion and is arranged in contact with a gap-side inner end of one of the operating pieces and with a gap-side inner end of the other operating piece such that one end of the coil spring presses one of the operating pieces of the operating member, and the other end pressing the other operating piece.

10. The binder according to claim 1, wherein the holding member is provided with a movement restricting portion on an inner surface of a holding wall inside of which the operating member is disposed, a latch of the opening/closing member extending towards the holding wall of the holding member is engaged with and held by a latching portion of the operating piece, while abutting against the movement restricting portion of the holding member, for restricting the movement in the holding member of the operating member disposed inside the holding member and of the opening/closing member for activating the operating member.

11. A method for manufacturing a binder including binding rings, a holding member having a length to allow said binding rings to be arranged with spacing therebetween, and an operating member on a surface of which said binding rings are anchored at bases thereof with a spacing therebetween, and which is movably fixed to an inner side of said holding member such that the binding rings are fixed to the holding member, said method comprising the steps of:

juxtaposing, inside the holding member, a pair of operating pieces constituting the operating member, one of the bases of each binding ring being fixed to one of said operating pieces and the other of the bases being fixed to the other operating piece, such that these operating pieces are capable of moving in a longitudinal direction of the holding member within the holding member;

inserting a pivot shaft through a pivot shaft portion formed at abutting edges of said pair of operating pieces from a pivot shaft insertion hole formed on a longitudinal central line of the holding member; and

fixing an opening/closing member to the pivot shaft portion, such that the opening/closing member moves the operating pieces within the holding member in the longitudinal direction of the holding member, while rotating the pair of operating pieces around said pivot shaft portion in directions

to open the binding rings.

12. The method for manufacturing a binder according to claim 10, wherein said step of juxtaposing the operating
5 pieces includes a step of juxtaposing a pair of operating pieces having a pivot shaft piece constituting the pivot shaft portion formed at the respective abutting edges such that the pivot shaft pieces of the pair of operating pieces are overlapped with each other; and
10 said step of inserting the pivot shaft includes a step of inserting the pivot shaft between said pivot shaft pieces.